

Work Order ID 83887

83887

Page 1

April-26-12 3:17:30 PM

Item ID: D4393-17 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Piano Hinge
 Start Date: 26/04/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 10/05/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/04/26 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4393	A								
100		0.00							
100									
Small Fab		0.00							
Small Fab	Memo								
	CRIMP AS PER DWG								
110		0.00							
110									
QC		0.00							
Quality Control	Memo								
	QC5- Inspect part completeness to step on W/O								
120		0.00							
120									
Packaging		0.00							
Packaging	Memo								
	Identify as per dwg & Stock. Location: <u>CA</u>								

PTO
12-06-06

2

FF
12-05-30

12-05-30

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
12/05/30	#115	Power coat white as per Day + 0251004 Start 4:10 Fin 4:40 temp 320 °F temp	M/L	12/05/30	2		S 12/05/30	
12/05/30	#116	QCS inspect Finish					S 12/05/30	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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April-26-12 3:17:30 PM

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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

12/6/12

MF
12-0606

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

April-26-12 3:17:34 PM

Page 1

Work Order ID: 83887

83887

Parent Item: D4393-17

D4393-17

Parent Item Name: Piano Hinge

Start Date: 26/04/2012

Required Date: 10/05/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 12-04-24 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MS20257P5-7200

Purchased

No

f

0.0000

1

MS20257P5-7200

n121582

**

Piano Hinge

Sp 12/05/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

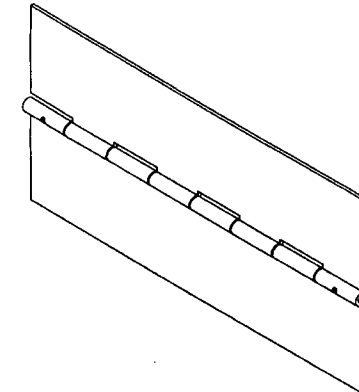
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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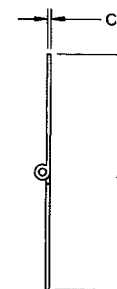
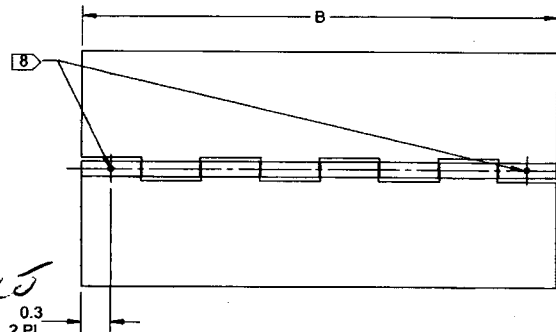
NOTE: Date & initial all entries

PART NUMBER	MAKE FROM	A	B	C	FINISH	MATERIAL (REF)
D4393-1	MS20257-1-3600	0.75	36.0	0.032	PER NOTE 2	AL 5052
D4393-3	MS20257P1-3600	0.75	36.0	0.032	ANODIZED AT SUPPLIER	AL 5052
D4393-5	MS20257-2-7200	1.06	72.0	0.040	PER NOTE 2	AL 5052
D4393-7	MS20257P2-7200	1.06	72.0	0.040	ANODIZED AT SUPPLIER	AL 5052
D4393-9	MS20257-3-7200	1.25	72.0	0.040	PER NOTE 2	AL 5052
D4393-11	MS20257P3-7200	1.25	72.0	0.040	ANODIZED AT SUPPLIER	AL 5052
D4393-13	MS20257-4-7200	1.50	72.0	0.040	PER NOTE 2	AL 5052
D4393-15	MS20257P4-7200	1.50	72.0	0.040	ANODIZED AT SUPPLIER	AL 5052
D4393-13	MS20257-5-7200	2.00	72.0	0.051	PER NOTE 2	AL 5052
D4393-17	MS20257P5-7200	2.00	72.0	0.051	ANODIZED AT SUPPLIER	AL 5052
D4393-13	MS20257-6-7200	2.00	72.0	0.064	PER NOTE 2	AL 5052
D4393-19	MS20257P6-7200	2.00	72.0	0.064	ANODIZED AT SUPPLIER	AL 5052



COPY
 RETURN TO
 ENGINEERING
 CONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER

83887 MLJ
 12/04/2012 PL



D4393-X PIANO HINGE

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4393-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: N/A
- 8) PUNCH OR CRIMP HINGE ENDS AT APPROXIMATE LOCATION SHOWN TO LOCK HINGE PIN IN PLACE.

RELEASED
 2011-05-26
 MD

A		NEW ISSUE		AJS	11.05.05
REV.		DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4393 TITLE PIANO HINGE		REV. A	
DRAWN	AJS			SHEET 1 OF 1	
CHECKED				SCALE	
MFG. APPR.				NTS	
APPROVED					
DE APPR.					
DATE	11.05.05	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

W/O:		WORK ORDER CHANGES					
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